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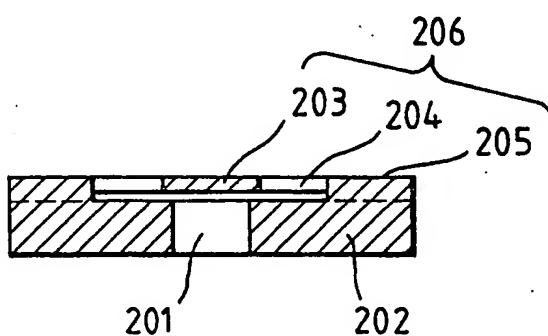
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㉚ Valve element for use in an ink-jet printer head.

㉛ A valve element for use in an ink-jet printer head comprises: a valve seat having a fine hole for a passage of a fluid, the valve seat being formed by a photoelectroforming technique; a valve for covering the hole; a support portion for supporting the valve and for displacing said valve in response to the pressure of said fluid; and a fixing portion for fitting the support portion to the valve seat, the valve, the support portion and the fixing portion being formed on the valve seat by a photoelectroforming technique in order to integrate the valve seat, the valve, the support portion and the fixing portion.



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VALVE ELEMENT FOR USE IN AN INK-JET PRINTER HEAD

This invention relates to a micro mechanical valve, and more particularly to a valve element which is suitable for an ink-jet printer head for jetting ink droplets by the pump action caused by the interaction between electromechanical conversion means and a 5 valve and for supplying the ink.

Conventional valve elements for ink-jet printer heads have been proposed in the U.S. Patent Application Serial No. 274,210 filed on June 16, 1981. The conventional valve element is constituted by superposing a disc-like valve seat having a cylindrical ink passage 10 at the center with a valve element for supporting a disc-like valve at the center by arms around the valve and a ring-like fixing portion. When a pressure acts upon the valve from the side of the ink passage, the valve is pushed up and the ink flows out through the gap between the valve and the valve seat. When the pressure acts in 15 the reverse direction, however, the valve is pushed to the valve seat, cutting the flow of the ink.

The diameter of the valve is greater than that of the ink passage and this difference is preferably as small as possible in order to facilitate the ink flow in the forward direction. This 20 means that extremely high accuracy is necessary in superposing the valve seat and the valve component. Accordingly, the assembly of the valve element is difficult, the yield of the approved valve element is low and variance of the characteristics is great.

Moreover, the assembly method described above is not suitable

for mass and economical production of a large number of valve elements.

It is, therefore, an object of this invention to provide a valve element for use in an ink-jet printer head which is suitable
5 for mass and economical production.

According to this invention, there is provided a valve element for use in an ink-jet head comprising: a valve seat having a fine hole for a passage of a fluid, said valve seat being formed by a photoelectroforming technique; a valve for covering said hole; a support portion for supporting said valve and for displacing said valve in response to the pressure of said fluid; and a fixing portion for fitting said support portion to said valve seat, said valve, support portion and fixing portion being formed on said valve seat by the photoelectroforming technique in order to integrate said valve seat, valve, support portion and fixing portion.
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Other features and advantages of this invention will be apparent from the following description of preferred embodiments of this invention taken in conjunction with the accompanying drawings, wherein:

20 Figs. 1(a) and 1(b) are a cross-sectional view and a plan view of a first embodiment of this invention, respectively;

Figs. 2(a) to 2(g) are cross-sectional views for illustrating method of producing the valve element according to the first embodiment of this invention; and

25 Figs. 3(a) to 3(c) are cross-sectional views for illustrating another method of producing the valve element.

Referring to Figs. 1(a) and 1(b), the first embodiment

comprises a valve seat 202 having at its center a fluid passage 201 having a circular cross-section, a valve 203 disposed so as to shield fluid passage 201, and a valve member 206 consisting of arms 204 supporting the valve 203 and a fixing portion 205. The valve member 5 206 is fixed to the valve seat 202 by the fixing portion 205. On the other hand, the valve 203 and the arms 204 are separated from the valve seat 202.

The planar shape of the valve member 206 may be arbitrary.

Fig. 1(a) shows a typical example in which the valve 203 is formed concentrically at the center of the ring-like fixing portion 205 and four arms 204 for supporting the valve 203 are disposed in the crisscross form. The diameter of the valve 203 is greater than that of the fluid passage 201. The valve seat 202 and the valve member 10 206 are formed by means of photoelectroforming technique as the combination of a patterning technique using a photoresist and plating technique, and corrosion-resist metals such as nickel, gold, chromium and the like are suitable as the metallic material. Since the valve member 206 is formed on the valve seat 202 using the same material by the photoelectroforming technique, the valve seat and the valve member 15 become a unitary structure. Even if the valve seat 202 and the valve member 206 are formed by different materials, the valve seat and the valve member will not separate from each other if a combination providing high bonding power at the fixing portion is 20 used.

In the first embodiment, an example of the size of the valve element suitable for an ink-jet printer head is as follows:

diameter of fluid passage 201: 180 μm

diameter of valve 203: $200 \mu\text{m}$ (provided that the valve member
is made of nickel)

width of support arm 204: $50 \mu\text{m}$

length of support arm 204: $400 \mu\text{m}$

5 thickness of valve member 206: approx. $10 \mu\text{m}$.

Referring to Figs. 2(a) to 2(g), the valve element according to the first embodiment is produced in accordance with the following production process: As shown in Fig. 2(a), a substrate 301 is formed by forming a conductive layer 303 on one surface of a glass sheet 302 by vacuum deposition. The conductive layer must be one that can be selectively etched against a material forming the valve element. Since the valve element is made of nickel in the first embodiment, the conductive layer consists of an aluminum layer and of a nickel layer from the side of the glass sheet 302. The nickel layer is a protective layer for the aluminum layer when plating is effected in a subsequent step. Hence, no problem occurs even if the aluminum layer alone is used. There is no particular limitation to the thickness of the aluminum layer and it ranges from several hundreds to several thousands of angstroms. However, a greater thickness is preferred because the aluminum layer is molten in the last step. The thickness of the nickel is from dozens to hundreds of angstroms and is preferably as thin as possible within the range in which it can protect the aluminum layer.

A photoresist layer 304 is formed on the substrate 301 described above. The pattern of the valve seat is exposed to light and a pattern having the conductive layer 303 exposed in the shape of the valve seat is formed by development. The thickness of the

photoresist layer is equal to that of the valve seat to be formed.

In this embodiment, 20 to 60 μm -thick resist is used. After the substrate is thus patterned by photoresist, the portion of the substrate devoid of the resist is plated by electroplating as shown
5 in Fig. 2(b), thereby forming the valve seat 305. Here, nickel is plated using a nickel sulfamate bath. The thickness of the plating needs be equal to that of the resist layer 304 and the difference of the thickness is preferably within $\pm 5 \mu\text{m}$.

Next, a spacer 306 is formed at the center as shown in Fig.
10 2(c). This is to be removed in the final step and is formed so as to separate the valve 203 and the arms 204 from the valve seat.

Then, a conductive layer 307 for effecting next electroplating is formed over the entire surface as shown in Fig. 2(d). It is preferably made of the same metal as the valve seat and this
15 embodiment uses vacuum deposited nickel. Alternatively, the nickel film can be formed by non-electrolytic nickel plating, for example. The pattern of the valve member consisting of the valve 309, the arms 310 and the fixing portion 311 is formed on the conductive layer 307 by the photoresist 308. The pattern 309 of the valve in this case is
20 formed in such a manner as to cover the resist pattern 304a of the hole of the valve seat. Since this can be made by mask registration at the time of exposure of the photoresist, the registration accuracy can be remarkably improved in comparison with the conventional method in which the valve seat and the valve member are produced
25 individually and are then superposed.

Among the pattern of the valve member, the spacer 306 does not exist below the fixing portion 311. Next, the valve member 312 is

nickel-plated by electroplating as shown in Fig. 2(f). The thickness of plating in this case may be irrelevant to the thickness of the resist layer 308 and can be determined in accordance with the fluid resistance value in the forward direction of the valve. It may be
5 about 10 μm , for example.

Finally, the conductive layer 303, the resist layers 304 and 308, and the spacer 306 are dissolved, providing the valve element as shown in Fig. 2(g). Since the conductive layer 303 is formed by aluminum, it can be selectively dissolved with respect to nickel that
10 forms the valve element, by use of sodium hydroxide. A solution that does not dissolve nickel but does the resist is used for the resist layers. In this step, if dissolution does not proceed because the surface of the spacer 306 is covered with the nickel conductive layer 307, the conductive layer 307 is etched and removed by an acid,
15 whereby the spacer 306 appears on the surface and can be dissolved.

Next, the second embodiment of the production method of this invention will be explained with reference to Figs. 3(a) to 3(c). The embodiment shown in Figs. 3(a) to 3(c) is different from the first production method in forming the spacer. In other words, the
20 steps till the formation of the valve seat in Fig. 2(b) are followed in the same way. Next, to form the spacer, an aluminum layer 401 is formed by vacuum deposition or the like on the upper surface of the nickel plating layer 305 and the resist layer 304 as shown in Fig. 3(a). Next, the pattern of the portion in which the spacer is formed
25 is formed on its surface by the photoresist 402 as shown in Fig. 3(b).

Further, the aluminum layer of the portion devoid of the

resist pattern 402 is etched and removed, whereby the spacer 403 consisting of aluminum is formed as shown in Fig. 3(c). Since this spacer is electrically conductive, the step of forming the pattern of the valve member consisting of the valve, the arms and the fixing portion, that is shown in Fig. 2(e), by the photoresist can be followed as the next step. In accordance with this method, since the spacer consists of the aluminum vacuum deposition film, it can be easily removed in the final step. Moreover, since it is thin, hardly any gap occurs between the valve and the arms versus the valve seat.

5 after the spacer is removed.

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Though the embodiment illustrates the case of the aluminum layer alone, a protective layer of nickel or the like may be disposed on the upper surface of the aluminum layer in the same way as the substrate if the aluminum layer is corroded by a plating solution

15 when electroplating of the pattern of the valve member is later electroplated.

As described above, this invention makes it possible to form all of the valve seat and the valve member (valve, arms and fixing portion) forming the valve element by photoelectroforming, and to

20 improve the dimensional accuracy of the valve element. Since locating between the fine hole of the valve seat and the valve can be made by mask registration, the position accuracy can also be improved.

Though the foregoing description deals with only one valve element, this invention can form simultaneously a large number of the valve elements of the same type on one substrate and since the accuracy of dimension and position is high, the valve elements having

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uniform characteristics can be mass-produced.

CLAIMS

1. A valve element for use in an ink-jet printer head comprising:
 - a valve seat having a fine hole for a passage of a fluid, said valve seat being formed by a photoelectroforming technique;
 - a valve for covering said hole;
 - a support portion for supporting said valve and for displacing said valve in response to the pressure of said fluid; and
 - 10 a fixing portion for fitting said support portion to said valve seat, said valve, said support portion and said fixing portion being formed on said valve seat by a photoelectroforming technique in order to integrate said valve seat, said valve, said support portion and said fixing portion.
2. A method of producing a valve element for use in an ink-jet printer head comprising steps of:
 - coating a photoresist having a predetermined thickness onto a substrate equipped with an electrically conductive layer on at least 5 its surface and removing said photoresist of a portion to be plated, thereby forming a pattern of a valve seat having a fine hole;
 - applying plating to the portion devoid of said resist so as to bury said portion by a predetermined metal to the thickness substantially equal to that of said resist, thereby forming said 10 valve seat;
 - forming, on the surface of said valve seat, a spacer at least the surface of which has conductivity, in such a manner that said

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spacer is positioned between a valve, support portion and said valve seat;

15 forming a pattern of a valve member on said valve seat having formed thereon said spacer, by photoresist, said valve member consisting of said valve arranged so as to cover said fine hole of said valve seat and having a predetermined size and shape greater than said fine hole and said support and fixing portions for said
20 valve;

plating the pattern of said valve member using a predetermined metal to form said valve member; and

removing the photoresist forming said valve seat pattern, and photoresist forming said valve member pattern and said spacer.

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Fig. 1(a)

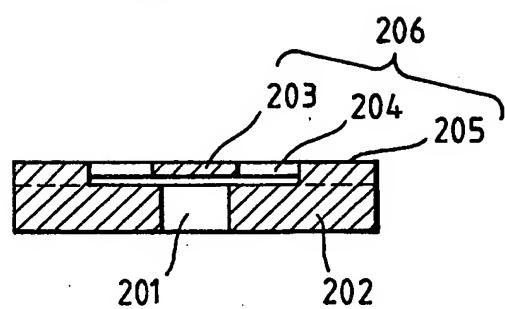
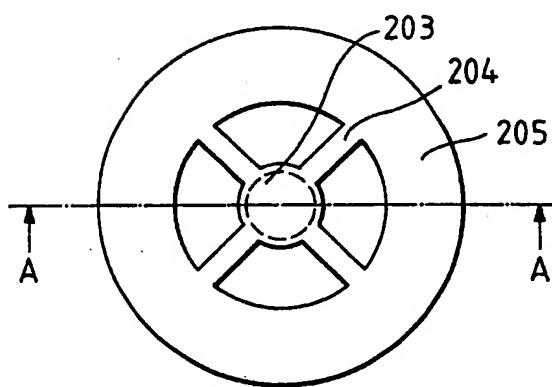


Fig. 1(b)



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Fig. 2(a)

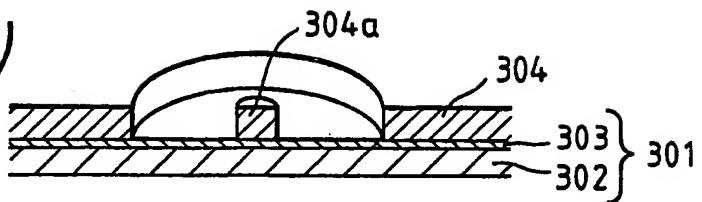


Fig. 2(b)

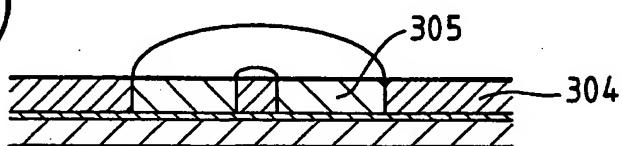


Fig. 2(c)

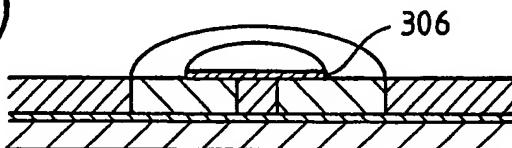


Fig. 2(d)

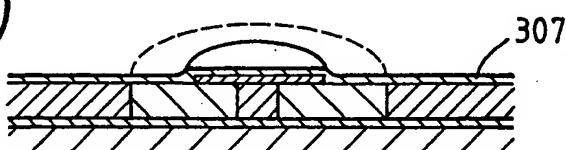


Fig. 2(e)

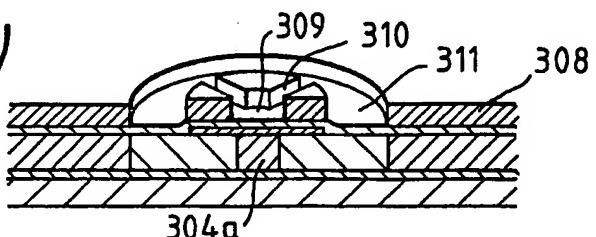
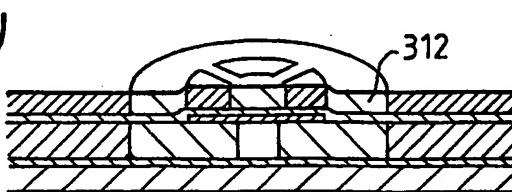


Fig. 2(f)



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Fig.2(g)

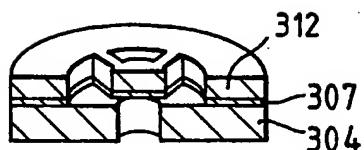


Fig.3(a)

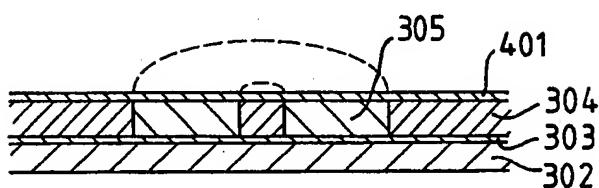


Fig.3(b)

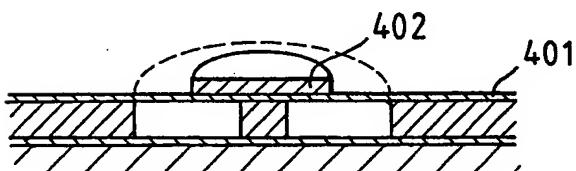
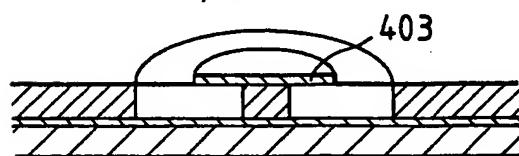


Fig.3(c)





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④ Valve element for use in an ink-jet printer head.

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⑨ References cited:
EP-A-0 052 914
GB-A-2 092 960

EP 0 112 701 B1

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Courier Press, Leamington Spa, England.

Description

This invention relates to a micro mechanical valve, and more particularly to a valve element which is suitable for an ink-jet printer head for jetting ink droplets by the pump action caused by the interaction between electromechanical conversion means and a valve and for supplying the ink.

In EP-A-0,052,914 a printer head for an ink-on-demand type ink jet printer has been proposed which has a disc valve arranged to control the flow of the ink. The valve element previously proposed is constituted by superposing a disc-like valve seat having a cylindrical ink passage at the center with a valve element for supporting a disc-like valve at the center by arms around the valve and a ring-like fixing portion. When a pressure acts upon the valve from the side of the ink passage, the valve is pushed up and ink flows out through the gap between the valve and the valve seat. When the pressure acts in the reverse direction, however, the valve is pushed to the valve seat, cutting the flow of the ink.

The diameter of the valve is greater than that of the ink passage and this difference is preferably as small as possible in order to facilitate the ink flow in the forward direction. This means that extremely high accuracy is necessary in superposing the valve seat and the valve component. Accordingly, the assembly of the valve element is difficult, the yield of the approved valve element is low and variance of the characteristics is great.

Moreover, the assembly method described above is not suitable for mass and economical production of a large number of valve elements.

It is, therefore, an object of this invention to provide a valve element for use in an ink-jet printer head which is suitable for mass and economical production.

In an embodiment of the invention to be described, there is provided a valve element for use in an ink-jet head comprising: a valve seat having a fine hole for a passage of fluid, said valve seat being formed by a photoelectro-forming technique; a valve for covering said hole; a support portion for supporting said valve and for displacing said valve in response to the pressure of said fluid; and a fixing portion for fitting said support portion to said valve seat, said valve, support portion and fixing portion being formed on said valve seat by the photoelectro-forming technique in order to integrate said valve seat, valve, support portion and fixing portion.

The invention is defined in claim 1.

Other features and advantages of this invention will be apparent from the following description of preferred embodiments of this invention taken in conjunction with the accompanying drawings, wherein:

Figs. 1(a) and 1(b) are a cross-sectional view and a plan view of a first embodiment of this invention, respectively;

Figs. 2(a) to 2(g) are cross-sectional views for illustrating method of producing the valve

element according to the first embodiment of this invention; and

Figs. 3(a) to 3(c) are cross-sectional views for illustrating another method of producing the valve element.

Referring to Figs. 1(a) and 1(b), the first embodiment comprises a valve seat 202 having at its center a fluid passage 201 having a circular cross-section, a valve 203 disposed so as to shield fluid passage 201, and a valve member 206 consisting of arms 204 supporting the valve 203 and a fixing portion 205. The valve member 206 is fixed to the valve seat 202 by the fixing portion 205. On the other hand, the valve 203 and the arms 204 are separated from the valve seat 202.

The planar shape of the valve member 206 may be arbitrary. Fig. 1(a) shows a typical example in which the valve 203 is formed concentrically at the center of the ring-like fixing portion 205 and four arms 204 for supporting the valve 203 are disposed in the crisscross form. The diameter of the valve 203 is greater than that of the fluid passage 201. The valve seat 202 and the valve member 206 are formed by means of photoelectroforming technique as the combination of a patterning technique using a photoresist and plating technique, and corrosion-resist metals such as nickel, gold, chromium and the like are suitable as the metallic material. Since the valve member 206 is formed on the valve 202 using the same material by the photoelectroforming technique. The valve seat and the valve member become a unitary structure. Even if the valve seat 202 and the valve member 206 are formed by different materials, the valve seat and the valve member will not separate from each other if a combination providing high bonding power at the fixing portion is used.

In the first embodiment, an example of the size of the valve element suitable for an ink-jet printer head is as follows:

diameter of fluid passage 201: 180 µm

diameter of valve 203: 200 µm (provided that the valve member is made of nickel)

width of support arm 204: 50 µm

length of support arm 204: 400 µm

thickness of valve member 206: approx. 10 µm

Referring to Figs. 2(a) to 2(g), the valve element according to the first embodiment is produced in accordance with the following production process: As shown in Fig. 2(a), a substrate 301 is formed by forming a conductive layer 303 on one surface of a glass sheet 302 by vacuum deposition. The conductive layer must be one that can be selectively etched against a material forming the valve element. Since the valve element is made of nickel in the first embodiment, the conductive layer consists of an aluminum layer and of a nickel layer from the side of the glass sheet 302. The nickel layer is a protective layer for the aluminum layer when plating is effected in a subsequent step. Hence, no problem occurs even if the aluminum layer alone is used. There is no particular limitation to the thickness of the aluminum layer and it ranges from several hun-

dreds to several thousands of angstroms. However, a greater thickness is preferred because the aluminium layer is molten in the last step. The thickness of the nickel is from dozens to hundreds of angstroms and is preferably as thin as possible within the range in which it can protect the aluminum layer.

A photoresist layer 304 is formed on the substrate 301 described above. The pattern of the valve seat is exposed to light and a pattern having the conductive layer 303 exposed in the shape of the valve seat is formed by development. The thickness of the photoresist layer is equal to that of the valve seat to be formed. In this embodiment, 20 to 60 μm -thick resist is used. After the substrate is thus patterned by photoresist, the portion of the substrate devoid of the resist is plated by electroplating as shown in Fig. 2(b), thereby forming the valve seat 305. Here, nickel is plated using a nickel sulfamate bath. The thickness of the plating needs be equal to that of the resist layer 304 and the difference of the thickness is preferably within $\pm 5 \mu\text{m}$.

Next, a spacer 306 is formed at the center as shown in Fig. 2(c). This is to be removed in the final step and is formed so as to separate the valve 203 and the arms 204 from the valve seat.

Then, a conductive layer 307 for effecting next electroplating is formed over the entire surface as shown in Fig. 2(d). It is preferably made of the same metal as the valve seat and this embodiment uses vacuum deposited nickel. Alternatively, the nickel film can be formed by non-electrolytic nickel plating, for example. The pattern of the valve member consisting of the valve 309, the arms 310 and the fixing portion 311 is formed on the conductive layer 307 by the photoresist 308. The pattern 309 of the valve in this case is formed in such a manner as to cover the resist pattern 304a of the hole of the valve seat. Since this can be made by mask registration at the time of exposure of the photoresist, the registration accuracy can be remarkably improved in comparison with the conventional method in which the valve seat and the valve member are produced individually and are then superposed.

Among the pattern of the valve member, the spacer 306 does not exist below the fixing portion 311. Next, the valve member 312 is nickel-plated by electroplating as shown in Fig. 2(f). The thickness of plating in this case may be irrelevant to the thickness of the resist layer 308 and can be determined in accordance with the fluid resistance value in the forward direction of the valve. It may be about 10 μm , for example.

Finally, the conductive layer 303, the resist layers 304 and 308, and the spacer 306 are dissolved, providing the valve element as shown in Fig. 2(g). Since the conductive layer 303 is formed by aluminum, it can be selectively dissolved with respect to nickel that forms the valve element, by use of sodium hydroxide. A solution that does not dissolve nickel but does the resist is used for the resist layers. In this step, if dissolu-

tion does not proceed because the surface of the spacer 306 is covered with the nickel conductive layer 307, the conductive layer 307 is etched and removed by an acid, whereby the spacer 306 appears on the surface and can be dissolved.

Next, the second embodiment of the production method of this invention will be explained with reference to Figs. 3(a) to 3(c). The embodiment shown in Figs. 3(a) to 3(c) is different from the first production method in forming the spacer. In other words, the steps till the formation of the valve seat in Fig. 2(b) are followed in the same way. Next, to form the spacer, an aluminum layer 401 is formed by vacuum deposition or the like on the upper surface of the nickel plating layer 305 and the resist layer 304 as shown in Fig. 3(a). Next, the pattern of the portion in which the spacer is formed is formed on its surface by the photoresist 402 as shown in Fig. 3(b).

Further, the aluminum layer of the portion devoid of the resist pattern 402 is etched and removed, whereby the spacer 403 consisting of aluminum is formed as shown in Fig. 3(c). Since this spacer is electrically conductive, the step of forming the pattern of the valve member consisting of the valve, the arms and the fixing portion, that is shown in Fig. 2(e), by the photoresist can be followed as the next step. In accordance with this method, since the spacer consists of the aluminum vacuum deposition film, it can be easily removed in the final step. Moreover, since it is thin, hardly any gap occurs between the valve and the arms versus the valve seat after the spacer is removed.

Though the embodiment illustrates the case of the aluminum layer alone, a protective layer of nickel or the like may be disposed on the upper surface of the aluminum layer in the same way as the substrate if the aluminum layer is corroded by a plating solution when electroplating of the pattern of the valve member is later electroplated.

As described above, this invention makes it possible to form all of the valve seat and the valve seat and the valve member (valve, arms and fixing portion) forming the valve element by photoelectroforming, and to improve the dimensional accuracy of the valve element. Since locating between the fine hole of the valve seat and the valve can be made by mask registration, the position accuracy can also be improved.

Though the foregoing description deals with only one valve element, this invention can form simultaneously a large number of the valve elements of the same type on one substrate and since the accuracy of dimension and position is high, the valve elements having uniform characteristics can be mass-produced.

Claim

60 A method of producing a valve element for use in an ink-jet printer head characterised in that it comprises the steps of:
65 coating a photoresist (304) having a predetermined thickness onto a substrate (301) equipped

with an electrically conductive layer (303) on at least its surface and removing the photoresist (304) of a portion to be plated, thereby forming a pattern of a valve seat (305) having a fine hole;

applying plating to the portion devoid of the resist so as to bury the portion by a predetermined metal to the thickness substantially equal to that of the resist, thereby forming the valve seat (305);

forming, on the surface of the valve seat (305), a spacer (306) at least the surface of which has conductivity, in such a manner that the spacer (306) is positioned between a valve (203), support portion (204) and the valve seat (305);

forming a pattern (309) of a valve member on the valve seat (305) having formed thereon the spacer (306), by photoresist (308), the valve member (312) consisting of the valve arranged so as to cover the fine hole of the valve seat and having a predetermined size and shape greater than the fine hole and the support (310) and fixing portions (311) for the valve;

plating the pattern of the valve member (312) using a predetermined metal to form the valve member; and

removing the photoresist (304) forming said valve seat pattern, and photoresist (308) forming said valve member pattern and the spacer (306).

Patentanspruch

Verfahren zum Herstellen eines Ventilelements zur Verwendung in einem Tintenstrahldruckkopf, gekennzeichnet durch die folgende Schritte:

Aufbringen einer Photolackschicht (304) mit einer bestimmten Dicke auf ein Substrat (301), das zumindest auf seiner Oberfläche eine elektrisch leitfähige Schicht (303) aufweist, un Entfernen des Photolacks (304) von einem Abschnitt, der mit einer Metallschicht überzogen werden soll, wodurch ein Muster eines Ventilsitzes (305) mit einem feinen Loch gebildet wird;

Aufbringen eines Metallüberzugs auf den Abschnitt, der keinen Photolack aufweist, in einer Dicke, die im wesentlichen gleich der des Photolacks ist, so daß der Abschnitt mit einem bestimmten Metall abgedeckt wird, wodurch der Ventilsitz (305) gebildet wird;

Ausbilden eines Abstandhalters (306), wobei mindestens seine Oberfläche leitfähig ist, auf der Oberfläche des Ventilsitzes (305) in solcher Weise, daß der Abstandhalter (306) zwischen einem Ventil (203), einem Stützabschnitt (204) und dem Ventilsitz (305) angeordnet ist;

Ausbilden eines Musters (309) eines Ventilelements auf dem Ventilsitz (305) mit dem darauf

gebildeten Abstandhalter (306), mittels Photolack (308), wobei das Ventilelement (312) aus dem Ventil besteht, das so angeordnet ist, daß es das feine Loch des Ventilsitzes abdeckt, und wobei das Ventilelement eine bestimmte Größe und Form hat, die größer als das feine Loch und eine Stützeinrichtung (310) und Befestigungsabschnitte (311) für das Ventil sind;

Aufbringen eines Metallüberzugs auf das Muster des Ventilelements (312) unter Verwendung eines bestimmten Metalls, wodurch das Ventilelement gebildet wird; und

Entfernen des Photolacks (304), der das Ventilsitzmuster bildet, und des Photolacks (308), der das Ventilelementmuster und den Abstandhalter (306) bildet.

Revendication

Procédé de fabrication d'un élément de clapet pour utilisation dans une tête d'imprimante à jet d'encre, caractérisé en ce qu'il comprend les étapes consistant à:

appliquer une photoréserve (304) ayant une épaisseur prédéterminée sur un substrat (301) muni d'une couche (303) conductrice de l'électricité sur au moins sa surface et enlever la photoréserve (304) d'une partie devant être revêtue, formant ainsi un motif d'un siège (305) de clapet, ayant un trou fin;

revêtir la partie démunie de réserve de manière à ensevelir cette partie avec un métal prédéterminé jusqu'à une épaisseur sensiblement égale à celle de la réserve, d'où la formation du siège (305) du clapet;

former, sur la surface du siège (305) du clapet, une entretoise (306), dont au moins la surface est conductrice, d'une manière telle que l'entretoise (306) est placée entre un clapet (203), une partie de support (204) et le siège (305) du clapet;

former un motif (309) d'un élément de clapet sur le siège (305) du clapet sur lequel est formée l'entretoise (306), par une photoréserve (308), l'élément de clapet (312) étant constitué du clapet disposé de manière à recouvrir le fin trou du siège de clapet et ayant une taille et une forme prédéterminées supérieures au fin trou et au support (310) et aux portions de fixation (311) pour le clapet;

revêtir le motif de l'élément de clapet (312) en utilisant un métal prédéterminé pour constituer l'élément de clapet; et

enlever la photoréserve (304) formant le motif du siège de clapet, et la photoréserve (308) formant le motif de l'élément de clapet et l'entretoise (306).

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Fig. 1(a)

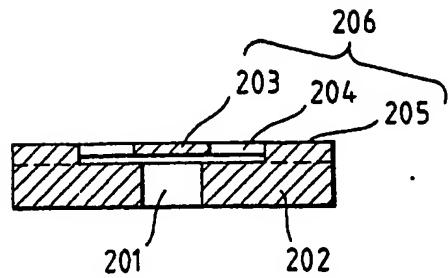
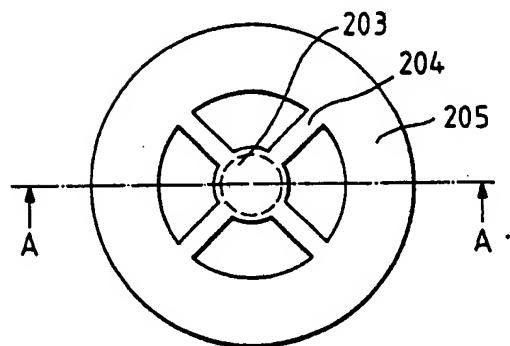


Fig. 1(b)



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Fig. 2(a)

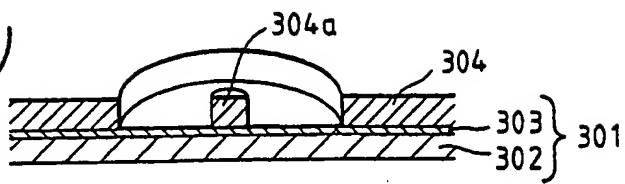


Fig. 2(b)

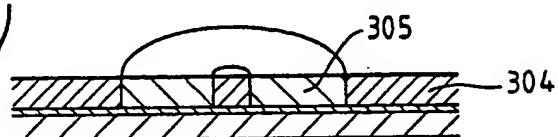


Fig. 2(c)

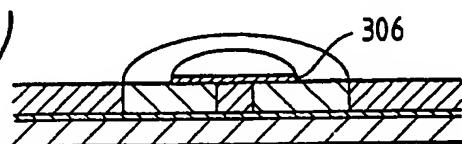


Fig. 2(d)

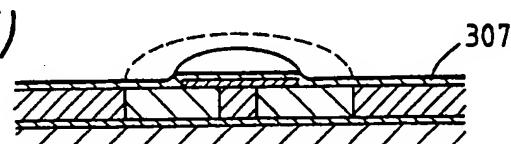


Fig. 2(e)

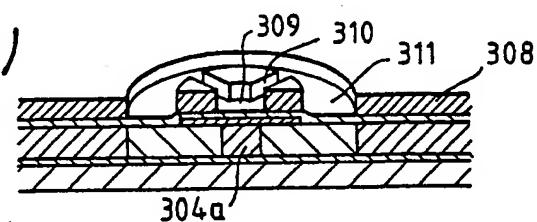
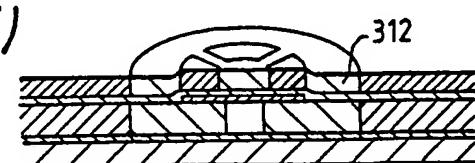


Fig. 2(f)



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Fig.2(g)

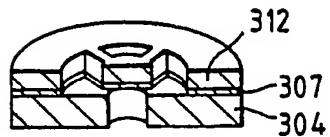


Fig.3(a)

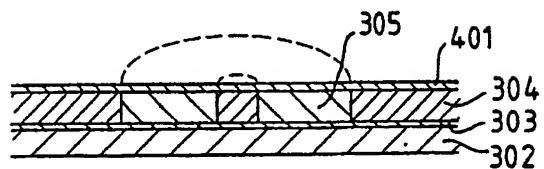


Fig.3(b)

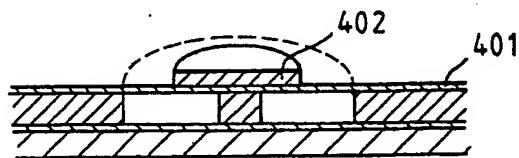


Fig.3(c)

